

## **ABSTRACT OF THE DISCLOSURE**

A system is provided for high volume print-forming of structures made up of multiple separate layers. A support bed is provided which has multiple steps arrayed thereon at different heights. Substrate blocks rest upon each of the steps. A printing process is utilized to print material from which the structures are to be formed down onto the substrate blocks. This printing process prints different layers onto each of the substrate blocks. The substrate blocks then move to a different step on the support bed and the printing process is repeated. Each support block has a partial structure thereon which receives its next successive layer in each printing cycle until the partial structure becomes a completed structure by having each of its layers sequentially printed thereon. Subsystems are provided for moving the substrate blocks upon the support bed and for properly holding and aligning substrate blocks upon the support bed.